NCR:	Yes	/ No				WORK ORDER NON-	COF	NFORN	MANCE / UP	DATE		QA Closed:	Da	te:	•
M - 1 - 0 - 1					-	DISPOSITION				AGAINST I	DEI	PARTMENT	PROCESS		*
Work Ord Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier	H	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Ac	tion		Sign &			
Cause											Date	Verificatio	n	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														. ,	
							AUL	LT CATE	GORY						
Bending Bend Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Crushed/Crimped. Burrs Cuffs Contamination Heat Treat Countersink Inspection Strip in Tube Cut Too Short Ripples in Bend Drill Holes						BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	/Unclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
Torque Waves in Extrusion Turning Sequence					' -	Drawing Finish	-	1	Calibration Seguence						
1															

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Work Orde November-30-12				*9420)7*				Page 2
Item KD: Revision ID: Item Name:	D350-607-5			Accept	*N90004	เก1กก*	-	tart 🛪	NS1*
Start Date: Required Date: Reference:	11/30/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				NO.
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):	Date:			ton	'NR1* 'NR2*
Sequence ID/ Work Center II 120 *170* QC Quality Control	D	Operation Description QC4- 100% Inspect kits Memo	for completeness	Set Up/ Run Hours 0.00 Si 0.00 J		ol# Plan Accept Code Qty	Reject Qty	Nun	oct Insp. nber Stamp AS 20 20 2-5
*130 *130* Packaging Packaging		Pick Kit Memo Package as p	per PPPD350-607-543	0.00	102		S.	<u>,</u> la	lialia sp
140 *1 △ ∩ * QC Quality Control		QC21- Final Inspection •	- Work Order Release	0.00			12	1/2	/20 D
									12-121

										DQA:	Date:	>
NCR:	Yes / N	lo			WORK ORDER NON-C	100	VFORM	MANCE / UPDATE				•
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Work Orde	ar.				DISPOSITION			AGAIN	ST DE	PARTMENT/	PROCESS	¥
Work Ordi					Rework	1		Skid-tube Crosstul	ne 🗀		Water Jet	Engineering
Part f	No.				Scrap	1	1	Machining Small Fa		Prod	d. Eng. Coor.	Quality
					Use-as-is	1		noforming Finishi	ng 🗀		e/Packaging	Other
NCR I	No.				Work Order Update	1		Large Fab Composi	-		Supplier	
						-			-			
Root				Descri	ption of work order update	l	Initial	Action		Sign &		
Cause	Dat	e Step	Qty	(or Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Doc/Data		1										
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Operator	Ш		1								10	
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Other												
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Supplier												
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Unapproved						<u> </u>						<u> </u>
		Ţ					T CATE	GORY				,
Landi	ng Gear	•		_	General	,,	· 1		_	1	_	1
	Bend	_			Bend	<u> </u>	Grain		-	Ovalized		Pressure/Forced
		e Not Conce	entric to	o/s _	BOM/Route	<u> </u>	Hardwa		\vdash	Over/Under	<u> </u>	Temperature/Cure
	Crack			<u> </u>	Broken/Damaged	\vdash	1	ion Incomplete	\vdash	Part Incorre	<u> </u>	Weld
*		ed/Crimped	l.	<u> </u>	Burrs	\vdash	4	ions Incomplete/Unclear	<u> </u>	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash	Mainte		<u> </u>	Part Moved		
	Heat	Treat		1	Countersink	1	Mislabe	eled	l	Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Picklist Print

November-30-12 10:11:03 AM

Work Order ID:

94207

Parent'Item:

D350-607-543

Parent Item Name: Heli-Utility-Basket

Start Date: 11/30/12

Required Date: 12/14/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ tem Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on e Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
230-60745101 puick Release Basket Mo	unting Installation	Manufactured	No				Each	4.0000	4	3950	25_	5	
				Location		Loc Oty	<u>1</u>	oc Code					
	:()			PK012		4							
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					702 325	l 1			9/	825			A
201046		M C . 1	No	900	523	1	Each	30.0000		100			
anyard Assembly		Manufactured	INO				Lacii	30.0000			48		3 %
,				Location		Loc Qty	Ī	oc Code					
Λ				GA		3							
5nD				919	957	3							
				ST014		. 27							
					568	2							
					542	1			<u> </u>	739			
					559 739	6			_7_	101			
					36 7	4							
				934		10							æ
3912-041 yebolt Receiver Assembl	lv	Manufactured	No				Each	3.0000		Cin'	V 2 9		
SM	,			Location		Loc Qty	<u>1</u>	oc Code					
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				920		2				2 200			<u> </u>
				92	798	1			_9	2798			A STORY
4030+043		Manufactured	No	~			Each	0.0000	a	11	^ ^ A A	1	1101
ong Basket Assembly, L	ight Lid (350)									Y JJ J	ys_		414

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-C		NFORM	MANCE / UPI				
									······································		QA Closed:	Date:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	₹
Part I	•		_			Rework Scrap Use-as-is		r	Skid-tube Machining Moforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	۷o. _.			,		Work Order Update]		Large Fab	Composite	,	Supplier	
Root			·		Descri	ption of work order update	1	nitial	Act	tion	Sign &		
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Landi	anding Gear				_	General		7		_	7	_	
Bending						Bend	\vdash	Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S					o/s	BOM/Route	<u> </u>	Hardwa		<u> </u>	Over/Under	<u></u>	Temperature/Cure
Cracks					<u> </u>	Broken/Damaged	<u></u>	4 .	ion Incomplete		Part Incorrect		Weld
Crushed/Crimped.				Burrs		1	ions Incomplete/	Unclear	Part Lost/Missing		Wrong Stock Pulled		
	\vdash	Cuffs			<u> </u>	Contamination	Maintenance				Part Moved		
	<u> </u>	Heat Trea	it		<u> </u>	Countersink	Mislabeled			Positioned Wrong		7	
Inspection Strip in Tube					1	Cut Too Short	1	Misroad	4		Power Loss	(Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-30-12 10:11:03 AM

Work Order ID:

94207

· Parent Item:

D350-607-543

Parent_Item Name:

Heli-Utility-Basket

Placard, Instructions

Placard, Max Load

5m)

No Manufactured

Location ST093

87037 ST095

87738

No

Manufactured

Location ST093

Location

Location

ST101

ST101

87674

90185

No

Manufactured

Manufactured

Basket Fwd Hardpoint Assembly, Lower

Basket Fwd Hardpoint Assembly, Upper

SMS

No

89111 91839 92138

89381 92741

Loc Oty

Each

Each

Each

Each

Loc Qty

Loc Qty

Loc Oty

11 11

12

2

10

12.0000

12.0000

8.0000

Loc Code

Loc Code

Loc Code

Loc Code

9.0000

Start Date: 11/30/12

Start Qty: 1.00

Required Date: 12/14/12 Required Qty: 1.00

•										DQA:	Date:	,
NCR:	Yes	/ No				WORK ORDER NON-C	ONFO	RMANCE / U	PDATE			•
	,									QA Closed:	Date:	
Work Orde	er:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	Ą
	- . No.		-	:		Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining ermoforming Large Fab	Crosstube Small Fab Finishing Composite	-∤	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat					o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink	Inspe Instr Mai	n ware ection Incomplete uctions Incomplet ntenance abeled	e/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned	lissing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
│ ├─- ┤ ├ ┤						Cut Too Short	Misread Power Loss/Surge				Other	
Ripples in Bend Drill Holes Offset							_			. 1		

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Picklist Print Page 3 November-30-12 10:11:03 AM Work Order ID: 94207 Parent Item: D350-607-543 Required Date: 12/14/12 **Start Date:** 11/30/12 Heli-Utility-Basket Parent Item Name: Start Qty: 1.00 Required Qty: 1.00 DATE OF THE PERSON No Each 15.0000 Manufactured Aftachment Arm Assembly Location Loc Code Loc Oty ST100 15 89232 3 90848 2 92513 92683 93281 5 No Each 669.0000 Purchased Bolt Location Loc Qty Loc Code FG 20 20 122808 GA 121652 Return2012 8 122416 ST356 640 120187 19 120770 12 122063 1 122416 10 122808 2 420 122993 123725 176 123525 Purchased No Each 19.0000 BOLT

5m/3

 Location
 Loc Qty
 Loc Code

 ST357
 19

 120124
 1

 121146
 1

17

122808

NCR: Y	Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:														
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		Bending				Bend		Grain			Oval	ized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	are	_	Ove	/Under	tolerance		Temperature/Cure
	Cracks Broken/Damaged Inspection Incomplete						Part	Incorre	ct		Weld				
	Crushed/Crimped Burrs Insti				Instruct	tions Incomplete/	Unclear	Part	Lost/M	issing		Wrong Stock Pulled			
Cuffs Contamination Maintenance						L	_	Moved							
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Inspection Strip in Tube Cut Too Short Misread						Pow	er Loss/	'Surge		Other					
Ripples in Bend Drill Holes					Drill Holes		Offset								
		Torque W	aves in E	Extrusio	n	Drawing		Out of	Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

November-30-12 10:11:03 AM

Work Order ID:

94207

Parent Item:

D350-607-543

Parent Item Name:

PIN, QUICK RELEASE

Heli-Utility-Basket

Start Date: 11/30/12

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

Nut	10C
Nut	

Purchased

No

Each

5mg	

- 0

Purchased

Purchased

No

123831

120360 121166 122800

114340

118612

123355

Location

ST343

122993 50 30 Each

Loc Oty

Loc Qty

95

13

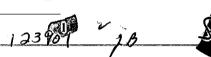
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95.0000

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No

123346

Location

ST331

2 6 Each

4,165.0000



Nut

Location Loc Qty ST314 4165 20 119017 122452 184 123021 1461 123248 900

2302



Cotter Pin

No Purchased

> Location Loc Qty ST323 223

1600

74

Each

149 122802 17566

Loc Code

223.0000

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Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
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Operator											
Material											
Setup											
Other											
Process											
Supplier											

FAULT CATEGORY

General

	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped_	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
Γ	Wave/Twist in Tube	Folio	Outside Dimensions		

Training Unapproved

Landing Gear

November-30-12 10:11:03 AM

Work Order ID:

94207

Parent Item:

D350-607-543

Parent Item Name:

Heli-Utility-Basket

Start Date: 11/30/12

Required Date: 12/14/12

Start Qty: 1.00

Required Qty: 1.00

Parent Item Name:	Heli-Utility-Basket							Start Q	t y: 1.00	Required Q	гу: 1.00
WASHER		Purchased	No	,			Each	365.0000		2 33	
				Location		Loc Qty		Loc Code			
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5mD					103691	8					
				ST298		357					
e fa					118709	2				∧ ->	
					120390	105			1203	<u>40</u>	
<u> </u>					123560	250				_ .	Λ.
Väsher		Purchased	No				Each	186.0000		12 V pB	5
<i>-</i> ₹				Location		Loc Qty		Loc Code		,	
5mB				ST295		186					
					121350	15					(Are.
					122151	13			4024	- A	
					123522	158			1235		ela-la-
Vasher	-	Purchased	No				Each	1,031.0000		B	12/0/10
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					123248	400					
					123355	200				<u>—</u>	

											DQA:	Date:	<u> </u>
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFORM	MANCE / UP	DATE			
											QA Closed:	Date:	
Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orac	٠					Rework]		Skid-tube	Crosstube		Water Jet	Engineering
Part N	No.					Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
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NCR 1	No.					Work Order Update]	l	Large Fab	Composite		Supplier	
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Root				1		ption of work order update	1	Initial		tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Desc	ription	Date	Verification	QC Inspector
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Landi	ing G	ear				General		_					
		Bending				Bend		Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S					o/s \Box	BOM/Route	Hardware				Over/Under	r tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

REFERENCE ONLY Sins

DART AEROSPACE LTD.

D350-607-3 Page 17 of 19

4.0 WEIGHT AND BALANCE

Installation	Weight	LA	TERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-607-541	80.7 lb	± 49.1 in	± 3962 in-lb	135 in	10895 in-lb	
(Standard Basket)	36.6 kg	± 1.25 m	± 45.8 m-kg	3.43 m	125.5 m-kg	
D350-607-543	65.7 lb	± 49.1 in	± 3226 in-lb	135 in	8870 in-lb	
(Lightweight Basket)	29.8 kg	± 1.25 m	± 37.3 m-kg	3.43 m	102.2 m-kg	
D350-607-545	58.7 lb	± 49.1 in	± 2882 in-lb	135 in	7925 in-lb	
(Standard Basket)	26.2 kg	± 1.25m	± 32,8 m-kg	3.43 m	89.9 m-kg	
D350-607-547	47.7 lb	± 49.1 in	± 2342 in-lb	135 in	6440 in-lb	
(Lightweight Basket)	21.6 kg	± 1.25 m	± 27.0 m-kg	3.43 m	74.1 m-kg	
D350-607-511 (Quick Release Basket Mounting Kit)	7.2 lb 3.3 kg	± 36.9 in ± 0.94 m	± 266 in-lb ± 3.1 m-kg	135 in 3.43 m	972 in-lb 11.3 m-kg	

5.0 PARTS LIST

QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
-541	-543	ী-545	-547	-511	-501		
X	~ ~~					D350-607-541	HELI-UTILITY-BASKET
	Х					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
<u> </u>			X			D350-607-547	HELI-UTILITY-BASKET
1	~1==	I	=1=	=x=	===	D350-607-511	TQUICK:RELEASE:BASKET.MOUNTING:KIT
					Х	D350-607-501	CONVERSION KIT
		7				-D2690-6	-L'ANYARD
1	a =				1		X-TUBE LUG
				4	41	D3910-3 -D3912-041	EYEBOLT RECEIVER ASSY
1		==			8		RUBBER EXTRUSION, X-TUBE
<u> </u>				8	8	D3984-030 D4030-041	LONG BASKET ASSY
1							TLONG BASKET ASSY, LIGHTWEIGHT
<u> </u>						D4030-043 D4032-041	SHORT BASKET ASSY
<u> </u>		1				D4032-041	SHORT BASKET ASSY, LIGHTWEIGHT
			1				EPLACARD-INSTRUCTIONS
1						D4085-3	PLACARD, MAX LOAD
11					1	-D4086-215	-PLACARDEMAXILOAD
	4=				1	D4086-220	PLACARD, MAX LOAD
<u> </u>		1				D4086-232	PLACARD, MAX LOAD
			11		1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4146-041	AFT X-TUBE LUG ASSY
<u> </u>				1	1	:D4149-041	-ATTACHMENT-ARM ASSY
1	-1-					-D4151:041	-ATTACHMENT-AKW ASST -BASKET-FWD-HARDPOINT-ASSY (LOWER).
1	41==				=-	-D4151-041	BASKET-FWD:HARDPOINT ASSY (UPPER)
1	4=					D4131-043-	EDMORETELEND-HANDFOINT AGGT (OFFER)
6	c 6===	==6==	6		6	AN4-13A	BOLT
<u> </u>				16	16	AN4-14A	_BOLT
1	e1==	=1=	1_		1_	AN4G15	BOLT
1	6					-AN310C4	-CASTELLATED NUT
1	¢1==	=1=	1_		1	-MS17984=C413	FQUICK RELEASE PIN
6	6-	6	6=	=16=	=22-	-MS21042L4	:NUT-(OR-MS21042-4)
1	€ -1				-1	-MS24665-151	COTTER:PIN
2	# 2=	<u>2</u>	=2=		 2—	-NAS1515H4L	EWASHER
12	£12-	12=	=12-	32	44-	NAS1149F0432P-	-WASHER -
3	3	=3 $=$			=3=	NAS1.149C0463R=	:WASHER,
<u> </u>		3	J_			-14EO-113-3-0-0-10-11-	

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